

JP4292906A EXTRUSION MOLDING METHOD FOR BOARDLIKE CEMENT PRODUCT

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PURPOSE: To enable high-precision molding without necessitating an extrusion auxiliary material, by a method wherein slurry obtained by compounding cement, quartz sand, a reinforcement fiber and aggregate with each other respectively at the specific rates is extrusion-molded comparatively thick, the molded body is sucked and dehydrated directly after the molding and molded into a fixed thickness.

CONSTITUTION: Slurry having density of 25-30% is obtained by adding water to a mineral compound comprising of 40-50wt.% cement, 40-50wt.% quartz sand, a 5-10wt.% reinforcing fiber such as a pulp fiber and the 5-10wt.% other necessary aggregate or light-weight aggregate (such as perlite). Then the slurry is extrusion-molded into a thickness of at least three times as thick as of that of a target product form by an extruder 1. Then simultaneously with compression of the surface of the slurry with linear pressure of about 1kg/cm by a rubber roll 3 directly after the molding, suction and dehydration are made to perform through the rear at about 400mm Hg by a suction box 4 and a molded board 2 having a fixed thickness is obtained. Then the molded board 2 is received by a receiving conveyor, cut into fixed lengths, then steam curing and hardening of the same are made to perform by an autoclave and a product is obtained.